

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF Rte: 80 PM: 13.2/13.9File #: 1x.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-001009**Date Inspected:** 14-Dec-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 600**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1300**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Benicia, CA**CWI Name:** William Norris**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Procedure Qualification Record (PQR) test**Summary of Items Observed:**

The Quality Assurance (QA) Inspector arrived at the Ironworkers Apprenticeship Training Facility and met with Smith-Emery Company Quality Control (QC) Inspector William Norris to observe QC functions during the welding of the Procedure Qualification Record (PQR) test plate listed below.

ABF-PQR-028-1.

1. The QC Inspector William Norris notified QA Inspector the weld profile of PQR test plate identified as ABF-PQR-028-1 was visually acceptable. The QA Inspector observed the visual verification of the weld profile appeared to be in accordance with the figure 3.3 of the AWS D1.5-2002 and general compliance with the project specifications.

a) The QA Inspector periodically observed American Bridge Floor (ABF) welding personnel Rick Clayborn perform air carbon arc cutting (gouging) and grinding on the ABF-PQR-028-1 test plate. The cutting was being performed to remove run off weld tabs and the grinding to remove the weld reinforcement to a smooth and flush finish to prepare test plate for final inspection and future Non Destructive Testing.

b) After cutting and grinding were completed the PQR test plate was visually inspected by QC Inspector William Norris. William Norris notified the QA Inspector the test plate was visually acceptable in accordance with AWS D1.5-2002. The QA Inspector performed visual verification and observed test plate appeared to be in general compliance with the project plans and specifications.

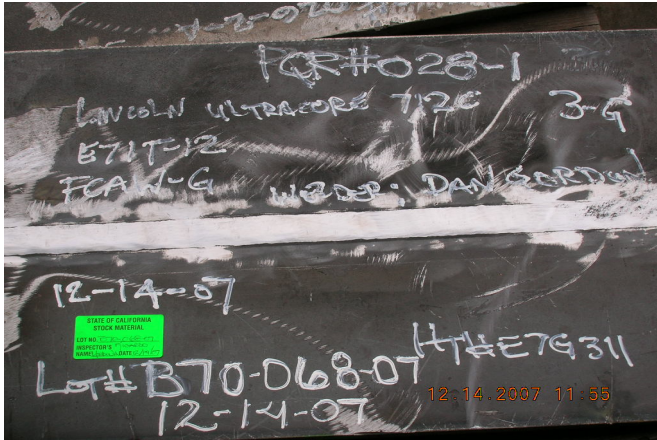
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c) QA Inspector assigned a Caltrans Index Lot Number to test plate for tracking purposes and a Welding Witness Report (TL-6032) was generated on this date. Please see digital images below.



### Summary of Conversations:

As noted in the body of the report above. The QA Inspector was notified by ABF welding foreman Rick Clayborn that due to testing material plates were not available at this time there will be no welding at this location on this date and that the ABF management was aware of this situation and had placed an order for additional testing material to continue welding to make more PQR testing plates at a later date. Other basic communication was performed between QA Inspector and the QC Inspector William Norris during observations.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Medina,Ricardo	Quality Assurance Inspector
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<b>Reviewed By:</b>	Mertz,Robert	QA Reviewer
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